

1634-015

Dart Aerospace Ltd.

Date: Thursday, 23/10/2008 1:23:09 PM
User: Julie Dawson

Process Sheet

Customer : CU-DAR001 Dart Helicopters Services
Job Number : 42894A
Estimate Number : 12520
P.O. Number :
This Issue : 23/10/2008 S.O. No. :
Prsht Rev. : NC
First Issue : // Type : SKIDTUBES
Previous Run : 42893A
Written By :
Checked & Approved By : JLD 8-10-23
Comment : Est Rev:C Revised Steps 06-09-06 JLM
Est Rev:D Added SS Wearplates & Gaskets 07-07-09 JLM

Drawing Name : SKID TUBE ASSEMBLY
Part Number : D205634045
Drawing Number : D2580 REV D
Project Number : N/A
Drawing Revision : D
Material :
Due Date : 01/02/2009 Qty: 1 Um: Each

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
1.0	DC	DOCUMENT CONTROL



Comment: DOCUMENT CONTROL

Photocopy D205-634 bluefile & type labels per PPP D205-634-045 CHG002

N/A

2.0

D25001190

Ext'n -1" Beam Tube 4"



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

Pick:

Qty Part Number

Description

Batch

1 D2500-1-190

Skid Tube Extrusion

B37544

JLD 8-11-12

3.0

D2596

Web, 205 Skidtube



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

Pick:

Qty Part Number

Description

Batch

1 D2596

205 Web

B37544

JLD 8-11-12

4.0

SKIDTUBES 1

SKIDTUBESS RESOURCE 1



Comment: LANDING GEAR RESOURCE 1

1- Inspect mat'l D2500-1-190 for damage

2-Cut D2500-1-190 per Dwg D2580 if necessary Deburr ends

3-Drill pilot holes using drill jig DT 8149

4-Acid etch and Alodine tube per QSI 005 4.1

JLD 8-11-13

W/O:		WORK ORDER CHANGES						
DATE	STEP	PROCEDURE CHANGE		By	Date	Qty	Approval Chief Eng/ Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Thursday, 23/10/2008 1:23:09 PM
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Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: SKID TUBE ASSEMBLY

Job Number: 42894A

Part Number: D205634045

Job Number:



Seq. #:

Machine Or Operation:

Description:

5-Open holes to 0.500" as per Dwg D2580 without cutting fluid

6-Countersink holes as per Dwg D2580 without cutting fluid

7-Deburr and blow out all chips from inside of tube

8-Add extra holes to web prior to bonding, per DEO 9183

9-Bond web in place per QSI 015. Allow 12 Hrs. cure time before cutting

Pick:

Qty Part Number Description Batch

A/R Sikaflex-291

Sikaflex expire date:

Start Time: 4:15 Date: 8-11-13

Fin Time: 8:30 Date: 8-11-13

JB 8-11-13

AUM
8-11-13

5.0

BENDING

BENDING MACHINE - SKIDTUBES



Comment: BENDING MACHINE

1-Bend as per program D2580.C on CNC Bender and Folio FT009

2-Cut tubes as per Dwg. D2580

JB 8-11-14

6.0

SKIDTUBES 1

SKIDTUBES RESOURCE 1



Comment: LANDING GEAR RESOURCE 1.

1-Deburr ends after cutting. Remove alodine from around holes

2-Drill extra fwd hole as per DEO 9183 using
drill jig DT8461

3-Drill extra middle hole as per DEO 9183 using
drill jig DT8462

4-Drill pilot holes for aft cap using DT8215, ***DO NOT OPEN TO FINISH SIZE***

5-Drill extra aft holes as per DEO 9183 using
drill jig DT8463 locating from aft cap hole and aft saddle hole.

JB 8-11-17

W/O:		WORK ORDER CHANGES								
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Job Number:



Seq. #: Machine Or Operation: Description :

7.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

BE 8-11-17

8.0

D25763

Step (maching detail)



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

Pick:

Qty	Part Number	Description	Batch
1	D2576-3	Step	238392

BE 8-11-17

9.0

D2579

Crossbolt Spacer



Comment: Qty.: 24.0000 Each(s)/Unit Total : 24.0000 Each(s)

Pick:

Qty	Part Number	Description	Batch
24	D2579	Spacers	41666

Job 8-11-17

10.0

SKIDTUBES 1

SKIDTUBESS RESOURCE 1



Comment: LARGE FABRICATION RESOURCE 1

1-Prepare tube for welding D2576-3 Step Remove alodine as required.

Job 8-11-17

2-Weld step D2576 as per Dwg. D2580 and QSI 004

A/R

Aluminum Rod

m/09813

BE 8-11-17

3-Weld crossbolt spacers D2579 as per Dwg. D2580 and QSI 004. For D2579

spacers, weld one

side, pass 3/8" drill, weld other side, pass 3/8" drill

A/R

Aluminum Rod

m/09813

BE 8-11-17

4-Grind welds as per Dwg D2580 Grind flush ridge made from bending

5-Drill holes for wearplates using DT 8217 Open holes to 19/64", adjust stopper not to hit web. Deburr

6-Counterbore crossbolt spacers to 7/16" ID x 1.0" deep as per Dwg D2580. Deburr holes

*****DO NOT COUNTERBORE EXTRA HOLES PUT IN AT STEP 13,14 AND 15 (LEAVE AT 0.384"Ø AS PER DEO 9183)****

7-Open aft cap holes to #6 Drill bit. Deburr

8-Drill pilot holes for Tow ring using DT8091, open to .640" and Deburr

AWM
8-12-16

W/O:		WORK ORDER CHANGES								
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Job Number: 42894A

Part Number: D205634045

Job Number:



Seq. #: Machine Or Operation: Description :

11.0

QC10

VISUAL INSPECTION OF GROUND WELDS



Comment: VISUAL INSPECTION OF GROUND WELDS

5 28/11/20 (X)

12.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

5 28/11/20 (X)

13.0

HAND FINISHING1

HAND FINISHING RESOURCE #1



Comment: HAND FINISHING RESOURCE #1

Pressure wash as per QSI 005

M-H 08/11/26

(1X)

14.0

POWDER COATING

POWDER COATING



Comment: POWDER COATING

Powder Coat ****GREEN****Sandtex (Ref: 4.3.5.8) as per QSI 005 4.3

START TIME:

OVEN TEMPERATURE:

FINISH TIME:

11:45
320°C
12:15

M-H 08/11/26

(1X)

15.0

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

08-11-26 (X)

16.0

D2855

Cap



Comment: Qty.: 1.0000 Each(s)/Unit Total: 1.0000 Each(s)

Cap

Batch:

1335920

Jel

17.0

AN35A

Bolt



Comment: Qty.: 2.0000 Each(s)/Unit Total: 2.0000 Each(s)

Bolt

Batch:

M100188

Jel

08-11-26 (X)

W/O:		WORK ORDER CHANGES							
DATE	STEP	PROCEDURE CHANGE			By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

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Drawing Name: SKID TUBE ASSEMBLY

Job Number: 42894A

Part Number: D205634045

Job Number:



Seq. #: Machine Or Operation: Description :

18.0 AN960JD10L Washer



Comment: Qty.: 2.0000 Each(s)/Unit Total: 2.0000 Each(s)

Washer

Batch: M1105793

JH

19.0 AN960C10L washer



Comment: Qty.: 50.0000 Each(s)/Unit Total: 50.0000 Each(s)

washer

batch M1109798

JH

20.0 ALS71032130 Insert



Comment: Qty.: 50.0000 Each(s)/Unit Total: 50.0000 Each(s)

Insert

Batch: M1105819

X JH

21.0 AN3C4A BOLT



Comment: Qty.: 50.0000 Each(s)/Unit Total: 50.0000 Each(s)

BOLT

Batch: M1109798

JH

22.0 D356613 Gasket



Comment: Qty.: 1.0000 Each(s)/Unit Total: 1.0000 Each(s)

GASKET

Batch: B42147

JH

23.0 D35665 Gasket



Comment: Qty.: 1.0000 Each(s)/Unit Total: 1.0000 Each(s)

GASKET

Batch: B41467

JH

24.0 D35661 Gasket



Comment: Qty.: 2.0000 Each(s)/Unit Total: 2.0000 Each(s)

GASKET

Batch: B43264

JH

08-11-26

(V1)

W/O:		WORK ORDER CHANGES								
DATE	STEP	PROCEDURE CHANGE				By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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Drawing Name: SKID TUBE ASSEMBLY

Job Number: 42894A

Part Number: D205634045

Job Number:



Seq. #: Machine Or Operation: Description :

25.0 D356413 Wearshoe



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

WEARSHOE

Batch: 1342257

Wearshoe

26.0 D356411



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

WEARSHOE

Batch: 1343192

27.0 D35649



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

WEARSHOE

Batch: 1342258

Wearshoe

28.0 D35645



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

WEARSHOE

Batch: 1342236

29.0 D25943



Comment: Qty.: 16.0000 Each(s)/Unit Total : 16.0000 Each(s)

O-Ring

Batch: 1329908

Plug, 205 Skidtube

30.0 D25941



Comment: Qty.: 16.0000 Each(s)/Unit Total : 16.0000 Each(s)

Plug

Batch: 1342807

31.0 HAND FINISHING1



HAND FINISHING RESOURCE #1



Comment: HAND FINISHING RESOURCE #1

1-Install inserts & wearplates as per Dwg. D2580. Use a drop of Sikaflex on insert holes before installing wearplates

A/R

Sikaflex-291

M 109942

JS

08.11.06

(JS)

W/O:		WORK ORDER CHANGES							
DATE	STEP	PROCEDURE CHANGE			By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: SKID TUBE ASSEMBLY

Job Number: 42894A

Part Number: D205634045

Job Number:



Seq. #:

Machine Or Operation:

Description :

✓ Sikaflex expire date: 08/11

✓ 2-Coat D2594-3 O' rings with Petroleum Jelly and install on D2594-1 plugs as per Dwg D2580

✓ 3-Inspect for foreign object per QSI 024

✓ 4-Install 2855 Aft Cap as per Dwg D2580 and seal Fwd Step & Aft Cap with Sikaflex. Clean excess adhesive

✓ A/R Sikaflex-291 M109942
Sikaflex expire date: 08/11

5-Wing Walk as per Dwg D2580 and QSI 005 4.4

M109917

Batch: M109917

08-11-22 (K)

32.0

QC5

INSPECT WORK TO CURRENT STEP



06/11/27 #0



Comment: Inspect Aft Cap, Fwd Step and Wing Walk of work to Current Step Inspect for Foreign objects per QSI 024

33.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and pack for shipping as per PPP D205-634-045

Location:

PPP Rev:

PPP 42894

8/11/28

last checked

SP

34.0

QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

08/12/01

Job Completion



MF 08-11-28

W/O:		WORK ORDER CHANGES							
DATE	STEP	PROCEDURE CHANGE		By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector	

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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			Initial Chief Eng	Action Description Chief, Eng	Sign & Date				

NOTE: Date & initial all entries

DART

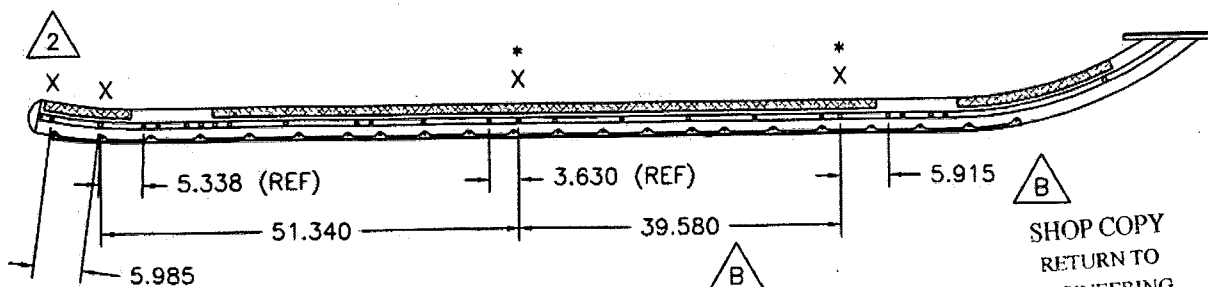
DESIGN RF	DRAWN BY RF	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED #	APPROVED #	DRAWING NO. DEO 9183	REV. B SHEET 1 OF 1
DATE 00.05.15		TITLE ADD SKIDTUBE P/N D2580-045	SCALE NTS
A	00.03.29	NEW ISSUE	
B	00.05.15	39.580 WAS 39.620	

DART ENGINEERING ORDER

AMEND DRAWING D2580 REV. C TO ADD D2580-045 ASSEMBLY

D2580-045 IS IDENTICAL TO D2580-041, EXCEPT FOR THE FOLLOWING CHANGES:

- 1) INSTALL CROSS BOLT SPACERS AT LOCATIONS MARKED 'X' ACCORDING TO THE FOLLOWING PROCEDURE.
 - a) DRILL $\varnothing 0.508$ HOLES AT LOCATIONS SHOWN BELOW MARKED 'X'. CHAMFER HOLES $0.030 \times 45^\circ$. NOTE THAT HOLES WILL ALSO HAVE TO BE TRANSFERRED TO THE D2596 WEB AT THE * LOCATIONS. IT IS ACCEPTABLE TO PRE-DRILL THE D2596 WEB IN THESE LOCATIONS BEFORE INSTALLING THE WEB IN THE SKIDTUBE. OPEN HOLES TO $\varnothing 0.63$ AND TOUCH UP WITH ALODINE PER QSI 005 4.1.
 - b) INSERT D2579 CROSS BOLT SPACERS INTO THE HOLES.
 - c) WELD INTO PLACE PER DART QSI 004 AND GRIND FLUSH.
 - d) REMOVE SPILL OVER LEAVING HOLE DIMENSION $\varnothing 0.380$ - $\varnothing 0.390$.
- 2) IT IS ACCEPTABLE TO GRIND A RELIEF IN THE D2855 AFT CAP TO PREVENT INTERFERENCE WITH THE SPACER AT THIS LOCATION.
- 3) POWDER COAT ENTIRE ASSEMBLY GREEN (REF. 4.3.5.8) PER DART QSI 005 4.3 INSTEAD OF WHITE (REF. 4.3.5.1).



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SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 42894A

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DESIGN RF	DRAWN BY RF	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED [Signature]	APPROVED [Signature]	DRAWING NO. DSI 9184	REV. A SHEET 1 OF 1
DATE 00.03.29		TITLE ADD SKIDTUBE P/N D205-634-015	SCALE NTS
A	00.03.29	NEW ISSUE	

DART SERVICE INSTRUCTION

TO AMEND INSTALLATION INSTRUCTIONS D205-634 REV. B.

REF. CANADIAN STA: SH96-88
US FAA STC: SR00563NY

ADD D205-634-015 INSTALLATION. PARTS LIST IS IDENTICAL
TO PARTS LIST FOR D205-634-011 EXCEPT THAT:
D205-634-045 REPLACES D205-634-041
D2580-045 REPLACES D2580-041

THE DIFFERENCE BETWEEN D205-634-011 (D205-634-041)
AND D205-634-015 (D205-634-045) IS THAT EXTRA
SPACERS HAVE BEEN ADDED AT LOCATIONS MARKED 'X' AND
ASSEMBLY IS PAINTED GREEN.



D205-634-015 (D205-634-045)

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NOTE: Date & initial all entries



DESIGN <i>[Signature]</i>	DRAWN BY <i>[Signature]</i>	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED <i>[Signature]</i>	APPROVED <i>[Signature]</i>	DRAWING NO. D2580	REV. D SHEET 1 OF 3
DATE 07.02.27		TITLE 205 SKIDTUBE ASSEMBLY SCALE NTS	
A	96.09.16	NEW ISSUE	
B	96.12.02	AS MANUFACTURED	
C	98.08.26	REDRAWN, INCLUDED DEO 9094/9097	
D	07.02.27	CHANGE TO SS WEARPLATES AND GASKETS, INCLUDE DEO 9124/9183	

RELEASED
07-06-28 *[Signature]*

QTY -041	QTY -045	Part Number	Description
X		D2580-041	SKIDTUBE ASSEMBLY
	X	D2580-045	SKIDTUBE ASSEMBLY
1	1	D2500-1-190	EXTRUSION
1	1	D2576-3	STEP
20	24	D2579	CROSS BOLT SPACER
16	16	D2594-1	PLUG
16	16	D2594-3	O-RING
1	1	D2596	205 WEB
1	1	D2855	AFT CAP
1	1	D3564-5	WEARSHOE
1	1	D3564-9	WEARSHOE
1	1	D3564-11	WEARSHOE
1	1	D3564-13	WEARSHOE
2	2	D3566-1	GASKET
1	1	D3566-5	GASKET
1	1	D3566-13	GASKET
50	50	ALS7-1032-130 or AKS7-1032-130 or AKS4-1032-130 or AELS-1032-130	INSERT
50	50	AN3C4A	BOLT
2	2	AN3-5A	BOLT
50	50	AN960C10L	WASHER
2	2	AN960JD10L	WASHER

GENERAL NOTES:

- 1) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 2) ALL DIMENSIONS ARE IN INCHES
- 3) INSERT D2596 WEB TO LOCATION SHOWN OFF AFT END OF SKIDTUBE AND BOND WEB INTO OUTER TUBE WITH NON-STRUCTURAL SIKAFLEX-241 ADHESIVE PER DART QSI 015 BEFORE BENDING. ENSURE HOLES LINE-UP.
- 4) BEND AS A SMOOTH RADIUS STARTING WITH A MAXIMUM CENTERLINE RADIUS OF 60 AND ENDING WITH A MINIMUM RADIUS OF 30. A MAXIMUM REDUCTION OF 0.200 IN DIAMETER IS ALLOWABLE IN THE BENT PORTION OF THE TUBE.
- 5) USE DART DRILL TEMPLATE TD2577-205 TO LOCATE AND DRILL $\varnothing 0.297$ HOLES FOR WEARSHOE INSERTS. INSTALL ALS7-1032-130 PER SECTION D-D (50 PLACES) AFTER FINISH. INSTALL AN3C4A BOLTS AND AN960C10L WASHERS WITH SIKAFLEX-241.
- 6) WELDING TO BE DONE PER DART QSI 004.
- 7) FINISH:
SEE NOTES ON
PAGE 2 FOR D2580-041 AND
PAGE 3 FOR D2580-045
- 8) INSERT D2594-1 PLUG C/W D2594-3 O-RING IN HOLES MARKED 'P' (BOTH SIDES OF TUBE) AFTER FINISH (16 PLACES).

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NOTE: Date & initial all entries

NO. 173

AWS D17.1.2001
QUALIFICATION TEST RECORD

Name: Barclay Elliott
Job number: 41315 A0
Part number: D204 635041
Description: 204/205 shield tube
Welding Process: Tig[☒] Mig[]
Base material: Aluminium
Current: AC[☒] DC[]

TEST REQUIREMENTS AND RESULTS

Visual: pass[☒] fail[]
Penetration: pass[☒] fail[]

UNACCEPTABLE

Cracks: pass[☒] fail[]
Undercut: pass[☒] fail[]
Pin holes: pass[☒] fail[]
Overlap (cold lap): pass[☒] fail[]
Porosity (surface): pass[☒] fail[]
Coloration: pass[☒] fail[]

Qualifier Pat Duval Date of Test Coupon 08-09-24
Welder Barclay Elliott Date of Test Coupon 08-09-24

The above named individual is qualified in accordance with AWS D17.1.2001 to weld

Diagram of a circular cross-section of a pipe with four vertical stiffeners. The stiffeners are spaced 3.500 units apart. The distance from the centerline to the outer edge of the stiffeners is 1.750 units.

RELEASED
07-06-28-11

Diagram illustrating the underside of a component, showing grinding locations and features:

- GRIND FLUSH (4 PLACES)
- GRIND FLUSH
- D2576-3 STEP
- GRIND FLUSH
- LOCATION RIDGE ON UNDERSIDE OF D2576
- $\frac{1}{4}$

Ø0.208

DRILL PRIOR TO D2855 CAP
INSTALLATION (2 PLACES)

SEAL WITH
SIKAFLEX-241/-291

AN3-5A BOLT (1)

AN960JD10L WASHER (1)
(2 PLACES)

D2855 CAP

0.40

5

D2579 SPACER

D2596 WEB (REF)

ALS7-1032-130 (REF)
(TYP 50 PLACES)

AFTER DRILLING AND BENDING ASSEMBLY
PERFORM THE FOLLOWING FOR Ø0.508 HOLES ONLY:

1. CHAMFER HOLE 0.050 X 45°
2. INSERT D2579 SPACER (20 PLACES)
3. WELD INTO PLACE AND GRIND FLUSH
4. C'BORE D2579 SPACER TO Ø0.437 X 1.00 DEEP

i) FINISH: ACID ETCH, ALODINE PER DART QSI 005 4.1 PRIOR TO INSERTING D2596 WEB POWDER COAT ASSEMBLY GLOSS WHITE (REF. 4.3.5.1) PER DART QSI 005 4.3 BLACK ANTI-SKID PAINT AS INDICATED PER DART QSI 005 4.4

Elevation view of the deck plate showing dimensions and reinforcement details:

- Top Left:** Triangle symbols containing the numbers 3 and 7.
- Top Center:** Dimension 37.50 with the label "DISTANCE TO AFT END OF D2596 WEB".
- Top Right:** Label "Ø0.508 (TYP.) (40 PLACES)" pointing to small circles representing reinforcement bars.
- Middle Right:** Label "REFER TO DETAIL A" with an arrow pointing to a circular cross-section of the beam.
- Bottom Left:** Label "REFER TO DETAIL A" with an arrow pointing to a circular cross-section of the beam.
- Dimensions (Horizontal):**
 - 8.750
 - 17.375
 - 26.000
 - 34.188
 - 57.313 (REF)
 - 7 EQUAL SPACES
 - 8.188 PITCH
 - 91.500
 - 190.0 (D2500-1)
- Vertical Spacing:** Two vertical dimension lines, each labeled 1.750, indicating the spacing between reinforcement layers.

[illegible]

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NO. 402894A

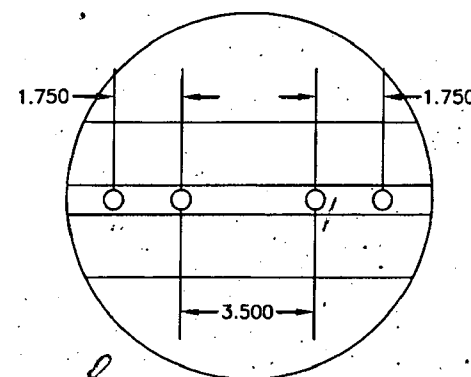
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07.02

TITLE
205 SKIDTUBE ASSEMBLY

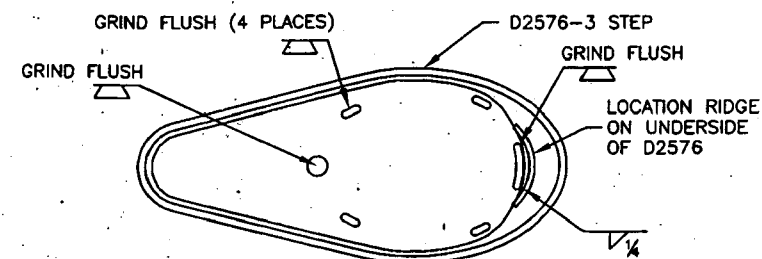
1:24 |

DETAIL E
SCALE 5:24

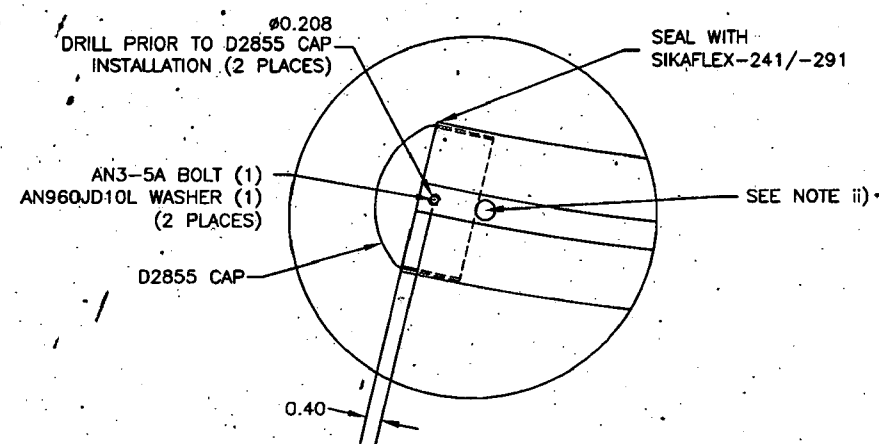


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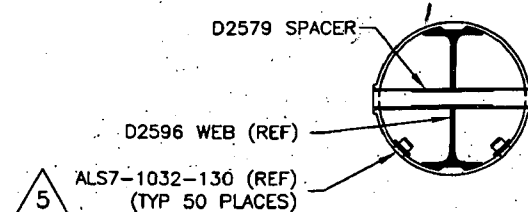
DETAIL F
SCALE 5:24



DETAIL G
SCALE 5:24



SECTION H-H
SCALE 5:24

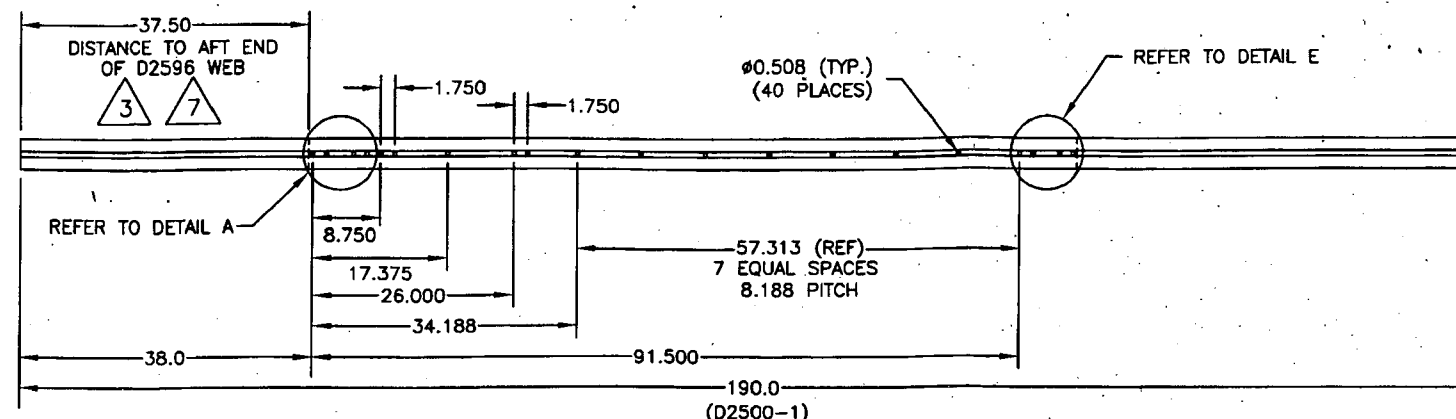


AFTER DRILLING AND BENDING ASSEMBLY PERFORM THE FOLLOWING FOR .00508 HOLES ONLY:
1. CHAMFER HOLE 0.050 X 45°
2. INSERT D2579 SPACER (20 PLACES)
3. WELD INTO PLACE AND GRIND FLUSH
4. C'BORE D2579 SPACER TO .00437 X 1.00 DEEP

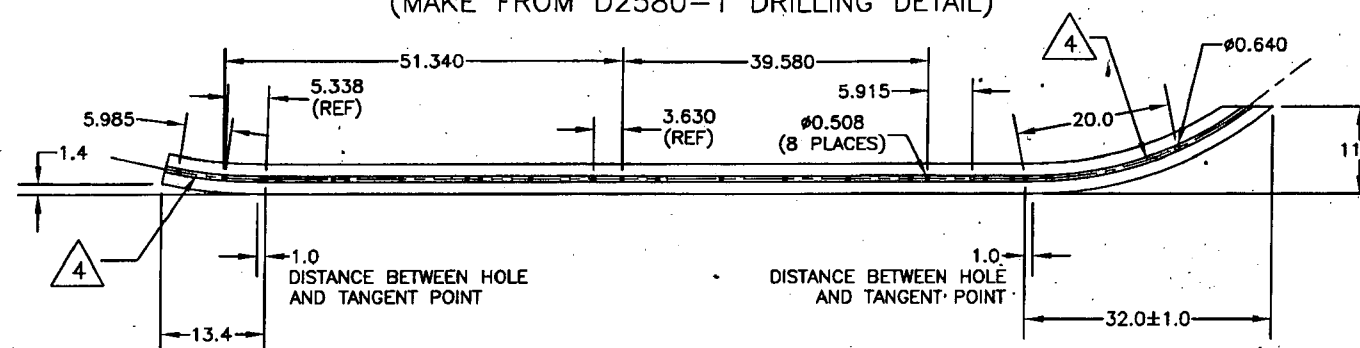
D2580-045 NOTES

- FINISH: ACID ETCH, ALODINE PER DART QSI 005 4.1 PRIOR TO INSERTING D2596 WEB POWDER COAT ENTIRE ASSEMBLY GREEN (REF. 4.3.5.8) PER DART QSI 005 4.3 BLACK ANTI-SKID PAINT AS INDICATED PER DART QSI 005 4.4
- IT IS ACCEPTABLE TO GRIND A RELIEF IN THE D2855 AFT CAP TO PREVENT INTERFERENCE WITH THE SPACER AT THIS LOCATION

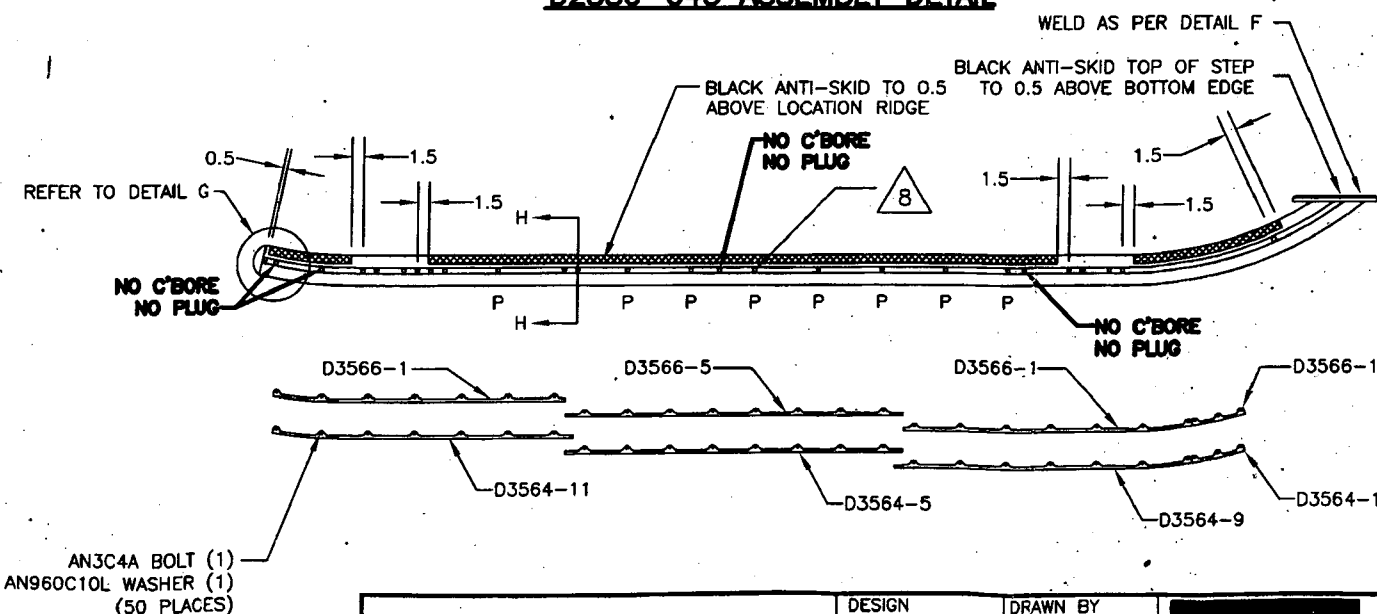
D2580-1 DRILLING DETAIL



D2580-5 BENDING AND CUTTING DETAIL
(MAKE FROM D2580-1 DRILLING DETAIL)



D2580-045 ASSEMBLY DETAIL



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CHECKED H	APPROVED H	DRAWING NO. D2580	REV. D SHEET 3 OF 3
DATE 07.02.27	TITLE 205 SKIDTUBE ASSEMBLY	SCALE 1:24	

